WOIR CHUCK ID 03732	Work	Order	ID	63952
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* Monday, November 22, 2010 9:15:20 AM



Page 1

Item ID:

D117-762-041

Accept

Setup Start

Stop



Ravision ID:

Item Name:

Replacement Skidtube

Start Date:

11/22/2010

Start Qty: 1.00

Required Date: 11/29/2010

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Date: 0-1/-22

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start Stop



Sequence ID/ Work Center ID

Operation

Description

Set Up/ **Run Hours** Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

Draw Nbr

Revision Nbr

D3582 Rev A

DC

DOCUMENT CONTROL

Memo

0.00

0.00

Document Control

Photocopy bluefile & type labels per PPP D117-762-041

CHG001

120

CNC Bend 1

CNC Delta 100 Bender

0.00

BENDING MACHINE - SKIDTUBES

Memo

0.00

Bend tube as per program D3582 on CNC Bender and Dwg D3582. Folio 3, use bending aid DT9632

2- cut fwd end of tube as per dwg

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W/O:			W	ORK ORDER CHA	NGES				•	.
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Required Date: 11/29/2010

Page 2

'Monday, November 22, 2010 9:15:20 AM

Item ID:

D117-762-041

Accept



Setup Start



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

11/22/2010

Start Oty: 1.00

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

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QC:

Process Plan: ______

Date:

Date: SPC (Y/N):

Tooling:

Date:

Date:

Run

Start



Stop



Sequence ID/ **Work Center ID**

130



Skidtubes

Skidtubes

Operation **Description** Set Up/ **Run Hours**

0.00

Tool ID

Tool # Plan

Accept Code Qty

Reject **Qty**

Reject Insp.

Number Stamp

Skidtubes

Memo

0.00

1-Cut Aft end using DT8185

2-Deburr ends

3-Drill Aft Cap holes using DT8678 ***DO NOT OPEN AFT CAP HOLE***

4-Locate DT 8973 & Drill Ground wire hole on top of Tube.

5-Install 3/16 cleco in Ground wire hole, then drill all X-Bolt holes using 3/16" drill.

6-Drill pilot holes for wearplates using DT8974

7-Open wearplate holes to Ø19/64" (0.297") as per Dwg D3582.

8- open ground wear holes to 0.391" as per section B-B

9-Open Aft Cap holes using .209" drill.

10-Drill pilot holes for section D-D and E-E. Holes must be laid out by hand. Mark out Center line and make sure that 6.65 and 5.906 measurements are respected. Double check before drilling, do not open holes to finish size.

Dart Aerospace

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Page 3

Monday, November 22, 2010 9:15:20 AM

Item ID:

D117-762-041

Accept



Setup Start



Stop

Revision ID:

Item Name:

Replacement Skidtube

Start Date:

11/22/2010

Start Qty: 1.00

Required Date: 11/29/2010

Req'd Qty: 1.00



Date: _____

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan: _ ____ Date: ____

Tooling:

SPC (Y/N):

Set Up/

Run Hours

Date: Date:

Tool # Plan

Code

Run

Accept

Qty

Start

Stop

1 & BEIGH



Reject

Qty

Number Stamp

Insp.

Reject

Sequence ID/ Work Center ID

140

Skidtubes Skidtubes

Skidtubes

QC:

Operation

Description

Memo

0.00

0.00

A/R AL ROD

2-Grind flush

1-Weld fwd cap D2964 per dwg D3582 and QSI 004 Batch: M//1.38

150

QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

10/12/02

Memo

Memo

160

QC

Quality Control

QC5- Inspect part completeness to step on W/O

500 Siolizlor

Dart	Aero:	space	Ltd
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Work Order ID 63952

Monday, November 22, 2010 9:15:20 AM



Page 4

Item ID:

D117-762-041

Accept

Setup Start

Stop

Revision ID:

Item Name:

Replacement Skidtube

Start Date:

11/22/2010

Start Qty: 1.00

Req'd Qty: 1.00 **Required Date:** 11/29/2010

Cust Item ID: Customer:

Reference:

Approvals:

QC:

Process Plan:

Date: Date:

Tooling: SPC (Y/N): Date:

Date:

Run

Start

Stop

Sequence ID/ Work Center ID

170

HandFinish

Hand Finishing

Operation Description

Chemical Conversion Coat per QSI005 4.1

Set Up/ **Run Hours**

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number Stamp

Insp.

180

Quality Control

Memo

QC3- Inspect Part Finish

0.00

10-12-6

0.00

Memo

0.00

Dart Aerospace L

W/O:			V	ORK ORDER CHANGE	S					· ·
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Monday, November 22, 2010 9:15:20 AM

Item ID:

D117-762-041

Accept



Date:

Date:

Setup Start



Stop

Revision ID:

Item Name:

Replacement Skidtube

Start Date:

11/22/2010

Start Qty: 1.00

Required Date: 11/29/2010

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: Date: Tooling:

BE 10/12/001

Run

Start Stop



Sequence ID/

Work Center ID

190



Skidtubes Skidtubes

Operation Description

Set Up/ Run Hours

0.00

SPC (Y/N):

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

10-12-7

Reject Number

Insp. Stamp

Skidtubes

Memo

0.00

1-Open X-Bolt holes to finish size as per Dwg D3582, all sections

2-Counter Sink X-BOLT holes as per Dwg D3582

3-Deburr and blow out chips from inside of tube, prep. tube for welding.

4-Bond web as per Dwg D3582 & QSI 015 A/R 241 Sike Flex Batch: 16040 Exp Date: 11-9-30

5-Weld x-bolt spacers(D2973) as per Dwg D3582 section B-B A/R AL ROD

6-Grind welds flush

QC10- Inspect visual per QSI004- ground welds

BE 10/12/09

Memo

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W/O:			W	ORK ORDER CHANG	ES		•	
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Work Order ID 63952

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Page 6

Item ID:

D117-762-041

Accept



Setup Start



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

11/22/2010

Start Qty: 1.00

Required Date: 11/29/2010

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

QC:

Process Plan:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run

Stop

Stop



Sequence ID/ **Work Center ID**

Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

Date:

Memo

Set Up/ **Run Hours**

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

215

HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

Memo

10/12/03

Touch-up alodine as per QSI

220

Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

0.00

0.00

1 /2/10-12-14.

W/O:			W	ORK ORDER CHANG	SES				•			
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Monday, November 22, 2010 9:15:20 AM



Page 7

Item ID:

D117-762-041

Accept

Setup Start



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

11/22/2010

Start Qty: 1.00

Required Date: 11/29/2010

Req'd Qty: 1.00



Date:

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

QC:

Process Plan:

Date: ____

Tooling:

Date:

Date:

Start Stop

Stop



Sequence ID/

Work Center ID

230

QC

Quality Control

Operation **Description**

QC3- Inspect Part Finish

Memo

Set Up/

SPC (Y/N):

Run Hours

10/12/14

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

240

HandFinish Hand Finishing HandFinishing

Memo

0.00

0.00

10/12/14

__Install Wearplate &Ground Wire inserts as per Dwg D3582.

W/O:			W	ORK ORDER CHAN	IGES			:	•	•
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Monday,	November	22,	2010	9:1



Page 8

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Hand Finishing		3-Install W Note:Instal section A/R 241 4-assemble A/R 55-o'n	D-D of dwg D3582 ****Do not install b Sika Flex Batch: Exp Da o'ring as per dwg D ing lube batch:	g D3582, on Ground Wire inserts or oolts where indicated on D	Dwg(Note #6)** e	****						
260 QC Quality Control		QC5- Inspect part comp	oleteness to step on \	0.00 0.00	s while	5			_@_			-

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Work Order ID 63952

Monday, November 22, 2010 9:15:20 AM



Page 9

Item ID:

D117-762-041

Accept

Setup Start



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

11/22/2010

Start Qty: 1.00

QC:

Operation

Description

Required Date: 11/29/2010

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan: _____ Date:

Req'd Qty: 1.00

Tooling: SPC (Y/N):

0.00

0.00

Set Up/

Run Hours

Date:

Date:

Tool # Plan

Code

Run

Start



Sequence ID/

Work Center ID

270

Packaging Packaging

Packaging

Date:

Location:

Memo

Identify and pack for shipping as per PPP D117-762-041

PPP Rev:________PNP 63980

280

QC21- Final Inspection - Work Order Release

0.00



Quality Control

Memo

0.00

Stop

Accept

Qty

Reject

Reject

Insp. Number

Stamp

10/12/23 Mrs-12-23

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Picklist Print

Monday, November 22, 2010 9:15:25 AM

Work Order ID: 63952

Parent Item: D117-762-041

Parent Item Name: Replacement Skidtube



Start Date: 11/22/2010

Required Date: 11/29/2010

Page 1

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A□07.06.11□New Issue□ EC

IPP Rev:B 08-02-22 change to revA as per dwg DD verified by:EC.

Component Item ID/	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status ?
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Cross Bolt Spacer											WEV	grayes	
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Monday, November 22, 2010 9:15:25 AM

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Work Order ID: 63952 D117-762-041 Parent Item: Parent Item Name: Replacement Skidtube Regaired Date: 11/29/2010 Start Date: 11/22/2010 Start Qty: 1.00 Required Qty: 1.00 2 D2973 No 190 Each 156.0000 2 Manufactured Cross Bolt Spacer Location Loc Oty Loc Code LG 156 BE 10/12/08 156 14636 D3662-3 190 Each 24.0000 Manufactured No Crossbolt Spacer Location Loc Qty Loc Code LG 24 _ BE10/2/18 24 44456 10.0000 190 Each D3662-1 Manufactured No Crossbolt Spacer Loc Qty Loc Code Location LG 10 55328 10 2,077.000 36 ALS4-1032-130 240 Each Purchased No Insert Location Loc Oty Loc Code PKG11 804 114723 804 ST281 1000 x36 1000 116049 ST282 234 110511 10 115911 224 39 ST381 114654 39

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Monday, November 22, 2010 9:15:25 AM

Work Order ID: 63952

Parent Item:

D117-762-041

Parent item Nar 2: Replacement Skidtube



Start Date: 11/22/2010

Lequired Date: 11/29/2010

Start Qty: 1.00

Required Qty: 1.00

D3558-3

Manufactured

No

250

Each

10.0000

Gasket

Manufactured

No

Location Loc Oty 10 42253 9 55468 250 Each

15.0000

Loc Code

10/12/14

Gasket

D3558-9

Gasket

D3558-11
- 1 100 100 110 110 110 110 110 110 110 110 110 110 110

Manufactured No FP 50928 55469

Location

FP

15 14 250 Each

Loc Oty

12.0000

Loc Code

Gasket

D3558-13		
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No Manufactured

Location Loc Qty Loc Code FP 12 12 62885 250 Each 32.0000

<u>Location</u>	Loc Qty
FP	32
59558	32

Loc Code

W/O:		WORK ORDER CHANGES : : :									
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NCR:			WORK ORD	ER NON-CONFORMA	NCE (NC	₹)			·		
DATE	STEP	Description of NC Section A	Corrective Action Section Initial Action Description			Verific Secti		Approval Chief Eng	Approval QC Inspector		
		Section A	Chief Eng	Chief Eng	Date			Office Eng	QC Inspector		
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Picklist Print

Page 5

Monday, November 22, 2010 9:15:25 AM

Work Order ID: 63952

D117-762-041

Parent Item:

Parent Item Nan.e: Replacement Skidtube



Start Date: 11/22/2010

Lequired Date: 11/29/2010

Start Qty: 1.00

Required Qty: 1.00

D3508-11

D3508-13

Wearplate	

Manufactured

No

Location Loc Qty FP16 9 _54644 250

250

Each

Each

Loc Code 14.0000

Loc Code

9.0000

Wearplate

D3492-051

Manufactured No

Manufactured

Location Loc Qty 14 63248 14 250

Each 48.0000

Il roll 14

Plug Assembly

D3492-049 Manufactured No Location Loc Oty FP013 48 44633 2 55622 46 250 Each

23.0000

Loc Code

10/12/14

Plug Assembly

Location FP011

55621

FP16

Loc Oty 23 23 Loc Code

W/O:		WORK ORDER CHANGES								•		
DATE	STEP	PROCEDURE CHANGE By Date Qty						Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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					:							
Part No:PAF		PAR #:	Fault Cate	Fault Category: NCR: Yes No DQA			A :	ı: Date:				
Resolution:			Disposition: QA			QA: N/C Closed: Date:						
NCR:			WORK ORDI	ER NON-CONFORM	IANCE	(NCR)					
DATE	STEP	Description of NC		Corrective Action Section B			Verifi	cation	Approval	Approval		
DATE	SILP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Sect	ion C	Chief Eng	QC Inspector		
												
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	1									1		

, Monday, November 22, 2010 9:15:25 AM

Work Order ID: 63952

D117-762-041

Parent Item Name: Replacement Skidtube

NAS1149D0332J Purchased

Purchased



Start Date: 11/22/2010

Required Date: 11/29/2010

Start Qty: 1.00

Required Qty: 1.00

D3492-053

Plug Assembly

Parent Item:

No Manufactured

250

Each

23.0000

Loc Code

10/12/14

No

No

62886

54641

115936

116075

Location FP

FP013

22 22 250

Loc Qty

Each 114884

Each

1000

1000

1

0.0000

2,115.000

2

28

10/12/10

Washer

AN3C4A

AN960JD10L

BOLT

Locatio	<u>n</u>	Loc Oty	Loc Code
ST303		3	
	115438	3	•
ST350		2112	
	115300	42	
	115589	70	

250

28

W/O:		WORK ORDER CHANGES								
DATE	STEP	PRO	ROCEDURE CHANGE			Date	Qty	Approval Chief Eng /	Approval	
					Ву			Prod Mgr	QC Inspector	
									'	
Part No:		PAR #:	Fault Cat	egory:	NCR: Yes	No DQ	\ :	Date:		
		esolution:				Date:				
NCR:		\	WORK ORE	DER NON-CONFORM	ANCE (NCF	?)		-		
		Description of NC		ction B	Veritic		Approval	Approval		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	k Section		Chief Eng	QC Inspector	
-										
-										
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· Monday, November 22, 2010 9:15:25 AM

Work Order ID: 63952

Parent Item:

D117-762-041

Parent Item Jame: Replacement Skidtube



Start Date: 11/22/2010

Required Date: 11/29/2010

Start Qty: 1.00

Required Qty: 1.00

AN3C5A

Bolt

Purchased

No

250

858.0000 Each

Locatio	<u>n</u>	<u>Lo</u>	c Qty	Loc Code		
ST350			848			
	114330		11			
	115015		13			
	115371		100			
	115422		100			
	115594		282			
•	115835		342			
ST351			10		1	XZ
*	113121		10			
		250	Each	186 0000	2	2

AN960JD416L

NAS1149D0416J Purchased

No

No

Loc Code

10/12/14

Washer	

NAS1149C0332

Purchased

ST346 106785 110153

Location

250

Loc Qty

186

184

2

Each

25.0000

28

washer

AN960C10L

Location Loc Qty ST245

107534

25

Loc Code

M11583Z

									•	
V/O:			WORK ORDER CHANGES							
DATE	STEP	PRO	OCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval. QC Inspector	
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							<u> </u>			
Part No:		PAR #:	Fault Categ	Fault Category: NC			A :	Date: _	<u> </u>	
	Re	esolution:	Disposition: Q			QA: N/C Closed: Date:				
NCR:			WORK ORDE	R NON-CONFORM	MANCE (NCI	7)				
DATE	STEP	Description of NC			ection B	Verifi	cation	Approval	Approval	
DAIL	SILI	Section A	Initial Chief Eng	Action Description Chief Eng	n Sign Date		ion C	Chief Eng	QC Inspector	
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Monday, November 22, 2010 9:15:25 AM

Work Order ID: 63952 Parent Item: D117-762-041 Parent Itc . Name: Replacement Skidtube **Required Date: 11/29/2010 Start Date:** 11/22/2010 Required Qty: 1.00 Start Qty: 1.00 AN4-4A 250 176.0000 Purchased No Each 10/12/14 Bolt Location Loc Qty Loc Code ST356 175 175 114615 ST361 1 111295 NAS1611-012 Purchased No 250 Each 92.0000 O-RING Location Loc Qty Loc Code FP 92 92 113845 NAS1611-015 98.0000 250 Each Purchased No O-RING Location Loc Qty Loc Code FP 98 ★ 107178 3 115101 16 116081 79 NAS1611-016 250 103.0000 Purchased No Each O-RING Location Loc Oty Loc Code FP 103 3 107178 112492 50 113524

Dail Ae	rospace	: Llu							۸
W/O:			WC	RK ORDER CHANGES				•	: -
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									*.
Part No):	PAR #:	Fault Cate	gory: I	NCR: Yes	No DQ	A:	Date: _	
	R	esolution:	Disposition	n; (QA: N/C C	osed:		Date: _	·•.
NCR:		` \	WORK ORD	ER NON-CONFORMAN	CE (NCF	3)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section E Action Description Chief Eng	Sign 8	k Sect	cation ion C	Approval Chief Eng	Approval QC Inspector
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PARTS LIST FOR D3582-041 SKIDTUBE ASSEMBLY

Qty	Part Number	Description
Х	D3582-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2964	CAP
1.	D2965	CAP
1	D2971	CROSS BOLT SPACER
2	D2973	CROSS BOLT SPACER
2	D3492-049	PLUG ASSEMBLY
2	D3492-051	PLUG ASSEMBLY
6	D3492-053	PLUG ASSEMBLY
1	D3508-3	WEARPLATE
1	D3508-9	WEARPLATÉ
1	D3508-11	WEARPLATE
1	D3508-13	WEARPLATE .
1	D3558-3	GASKET
1	D3558-9	GASKET
1	D3558-11	GASKET
1	D3558-13	GASKET
1	D3584-1	WEB .
3	D3662-1	CROSS BOLT SPACER
1	D3662-3	CROSS BOLT SPACER
36	AELS-1032-130	INSERT
2	ALS7-428-165	INSERT
28	AN3C4A	BOLT
2	AN3-5A	BOLT
2	AN4-4A	BOLT
28	AN960C10L	WASHER
2	AN960JD10L	WASHER
2	AN960JD416L	WASHER

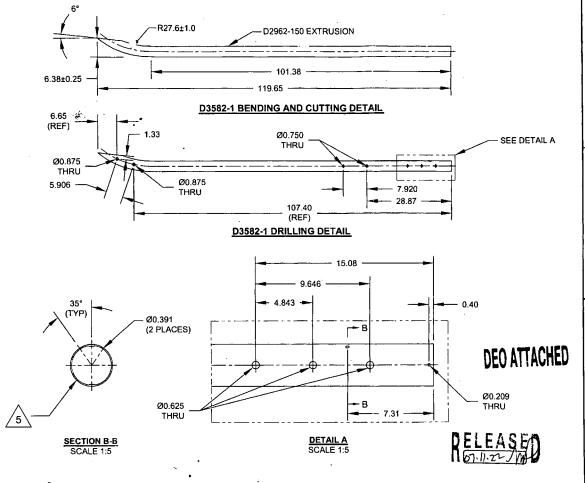
GENERAL NOTES:

С

- 1) ALL DIMENSIONS ARE IN INCHES
 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 3) WELDING TO BE DONE PER DART QSI 004.
 4) INSERT D3584-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING.
 5) USE DART DRILL TEMPLATE DT8500 TO LOCATE AND DRILL @0.297 HOLES (36 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION G-G (36 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
 6) DO NOT INSTALL AN3C4A BOLTS: AND AN960C10L WASHERS IN INDICATED LOCATIONS.

- LOCATIONS.
 7) FINISH:
- 4.7 A) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3584-1 WEB.

 - B) POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3.
 C) ANTI-SKID PÄINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI



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SUMBERT TO AMENDMENT

WILLIOUT NOTICE

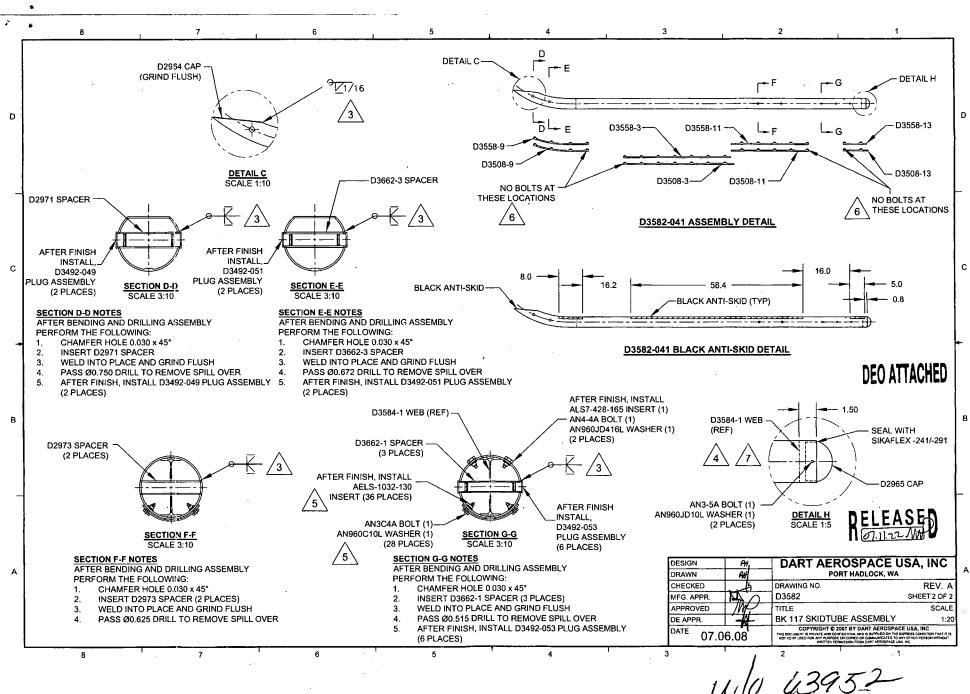
WOLK ORDER

07.06.08 NEW ISSUE Α DESCRIPTION BY DATE REV. DESIGN DART AEROSPACE USA, INC PORT HADLOCK, WA DRAWN CHECKED DRAWING NO. REV. A D3582 SHEET 1 OF 2 MFG. APPR. APPROVED TITLE SCALE **BK 117 SKIDTUBE ASSEMBLY** DE APPR. 1:20 COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. 07.06.08

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W/O:		WORK ORDER CHANGES								
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No:		PAR #:	Fault Ca	tegory:	_ NCR: Yes	No DQA:	Date:			
	R		Disposition: Q							
NCR:		\	WORK OR	DER NON-CONFORMA	NCE (NCF	1)				
DATE	STEP	Description of NC	Description of NC Section A Initial Action Description			Sign & Verification		Approval		
		Section A	Chief Eng	Chief Eng	Date	Section C	Chief Eng	QC Inspector		
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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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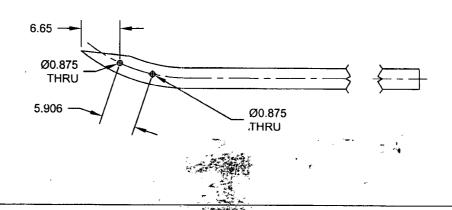
Part No:		PAR #:	Fault Category: _	 NCR: Yes No	DQA:	Date:	
	Resolution:	<u> </u>	Disposition:	 QA: N/C Closed	l:	Date:	

NCR:		••	WORK OR	DER NON-CONFORMANC	E (NCR)	•		
		Description of NO		Corrective Action Section B		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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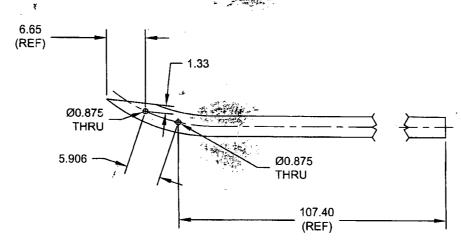
DRÁWING NO	O. TITLE	, REV. A	DART AEROSPACE US	A, INC D.E.O. NO.	SHEET NO.	SCALE
Ď3582	BK 117 SK	(IDTUBE ASSEMBLY	ENGINEERING ORD	D3582-A-1	SHEET 1 OF 1	NTS
ĎRAWN	P U	CHECKED	MFG. APPR.	APPROVED (N)	DE APPR.	· · · · · · · · · · · · · · · · · · ·
DATE	09.04.06	DATE 64.04.06	DATE 09.04.06	DATE 19104/Dh	DATE 09.04-00	P

FOR EASE OF MANUFACTURE AND TO ENSURE THE FIT OF BRISTOL WIRESTRIKE SKID GEAR DEFLECTOR: UPDATE DIMENSIONING OF 2 FWD HOLES ON SHEET 1 AS SHOWN

IS:



WAS:



Wlo 63952

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No:		PAR #:	Fault Category:	***	NCR: Yes No D)QA:	Date:
•	Ä.						
·	Resolution:		Disposition:		QA: N/C Closed:		Date:

NCR:		W	ORK ORD	ER NON-CONFORMANCE	E (NCR)		and the second	
·		Description of NC	e N. S	Corrective Action Section B		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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AWS D17.1.2001 QUALIFICATION TEST RECORD

2 .								
Name: Barchay Elli	tte							
Job number: 54161								
Part number: Dill-762.0)4 <u> </u>							
Description: 117 -k.d	Description: 117 sk.d tube							
Welding Process: Tig[/] I	Mig[]							
Base materiel: Alumini	wn							
Current: AC[/] DC[]								
<u>TES</u>	T REQUIREMENTS AND RESULTS							
¥7:	5 Å C 37 3							
Visual:	pass[/] fail[]							
Penetration:	pass[] fail[]							
TINI A CICEDITIA DY E								
<u>UNACCEPTABLE</u>								
Cracks:	pass[\] fail[]							
Undercut:	pass[/] fail[]							
Pin holes:	pass[/] fail[]							
Overlap (cold lap)	pass[v] fail[]							
Porosity (surface):	pass[/] fail[]							
Coloration:								
Coloration:	pass[~] fail[]							
Qualifier / d / /	Date of Test Coupon 09/210							
D 11 0111								
Welder Darlange thu	Date of Test Coupon 09/12/10							

The above named individual is qualified in accordance with AWS D17.1.2001 to weld